



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

RBE117-11181W1
Job Sheet 175881



Part No: RBE117-11181W1

Job Qty: 4 ea

Part Name: Main Rotor Drive Mounting Tool



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 4/11/18

Job Tracking No:

Due Date: 5/11/18

Created By: Marie Lajeunesse

Type: Stock

Description:

Note: Dwg. RBE117-11181W1 Rev.1 IPP Rev.A New issue 18/02/06 JFS Verified by: DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
60	Purchasing	4 pcs		5/11/18	0.00	0.00	Purchasing Start Up		AT 18/05/18
70	Packaging	4 pcs		5/11/18	0.00	0.00	Packaging2		AT 18/05/18
80	QC	4 pcs		5/11/18	0.00	0.00	QC6		38
90	Small Fab	4 pcs		5/11/18	0.00	0.00	Small Fab-2		N/R
110	Small Fab	4 pcs		5/11/18	0.00	4.00	Small Fab		N/R
120	QC	4 pcs		5/11/18	0.00	0.00	QC4		N/R
130	Packaging	4 pcs		5/11/18	0.00	0.00	Packaging3		18-05-15 GA 134
140	QC21-FG	4 Ea		5/11/18	0.00	0.00	QC21		DAS MAY 1 2018

Part Op 60 - Issue PO to ARROW TECH MACHINE WORKS P/O: 39580 MANUFACTURE RBE117-11181W1 AS PER Descriptions: DWG. -Certificate of conformity is required

110 - 1-Press fit RBE117-11181W1-5 in RBE117-11181W1-3 as per Dwg. RBE117-11181W1-1. 2-Press fit RBE117-11181W1-17 in RBE117-11181W1-15 as per Dwg. RBE117-11181W1-13. 3-Engrave placard RB41011 using marktronic engraver 4-Transfer drill Dart placard RB41011 into Pelican case APP-1200-E 5-Deburr holes and remove chips from case. 6-Rivet Dart placard to Pelican case 7-Glue placard RBE117-11181W1-25 to RBE117-11181W1 foam as per DWG. 8-Glue foam to case and pack case as per DWG.

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MAY 14 2018

DAS
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Main Rotor Drive Mounting Tool

PART NO: RBE117-11181W1

Serial No/Batch: S071245

Revision:

Operation:

Change No:

Packaging

Mfg Date: 05/14/18

Job No: 175881

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
RBE117-11181W1P	Main Rotor Drive Mounting Tool	4 Ea (1 ea)	60-Purchasing	5071244
97524A032	Sealing Blind Rivet	16 Ea (4 ea)	90-Small Fab	
APP-1200-E	Case	4 Ea (1 ea)	90-Small Fab	
RB41011	Dart Tooling Placard, Aluminum	4 Ea (1 ea)	90-Small Fab	
RBE117-11181W1-11	Thrust Piece Å~12mm	4 Ea (1 ea)	90-Small Fab	
RBE117-11181W1-15	Support Å~15mm	4 Ea (1 ea)	90-Small Fab	
RBE117-11181W1-17	Guide Bolt Å~15mm	4 Ea (1 ea)	90-Small Fab	
RBE117-11181W1-19	Insert Å~15mm	4 Ea (1 ea)	90-Small Fab	
RBE117-11181W1-21	Forming Die Å~15mm	4 Ea (1 ea)	90-Small Fab	
RBE117-11181W1-23	Thrust Piece Å~15mm	4 Ea (1 ea)	90-Small Fab	
RBE117-11181W1-25	Contents Placard	4 Ea (1 ea)	90-Small Fab	
RBE117-11181W1-27	Bottom Foam use in case APP-1200-E	4 Ea (1 ea)	90-Small Fab	
RBE117-11181W1-29	Top Foam use in case APP-1200-E	4 Ea (1 ea)	90-Small Fab	
RBE117-11181W1-3	Support Å~12mm	4 Ea (1 ea)	90-Small Fab	
RBE117-11181W1-5	Guide Bolt Å~12mm	4 Ea (1 ea)	90-Small Fab	
RBE117-11181W1-7	Insert Å~12mm	4 Ea (1 ea)	90-Small Fab	
RBE117-11181W1-9	Forming Die Å~12mm	4 Ea (1 ea)	90-Small Fab	

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
60-Purchasing	RBE117-11181W1P	4	0	0
90-Small Fab	97524A032	16	259	0
	APP-1200-E	4	9	0
	RB41011	4	913	0
	RBE117-11181W1-11	4	0	0
	RBE117-11181W1-15	4	0	0
	RBE117-11181W1-17	4	0	0
	RBE117-11181W1-19	4	0	0
	RBE117-11181W1-21	4	0	0
	RBE117-11181W1-23	4	0	0
	RBE117-11181W1-25	4	5	0
	RBE117-11181W1-27	4	9	0
	RBE117-11181W1-29	4	9	0
	RBE117-11181W1-3	4	0	0
	RBE117-11181W1-5	4	0	0
	RBE117-11181W1-7	4	0	0
	RBE117-11181W1-9	4	0	0

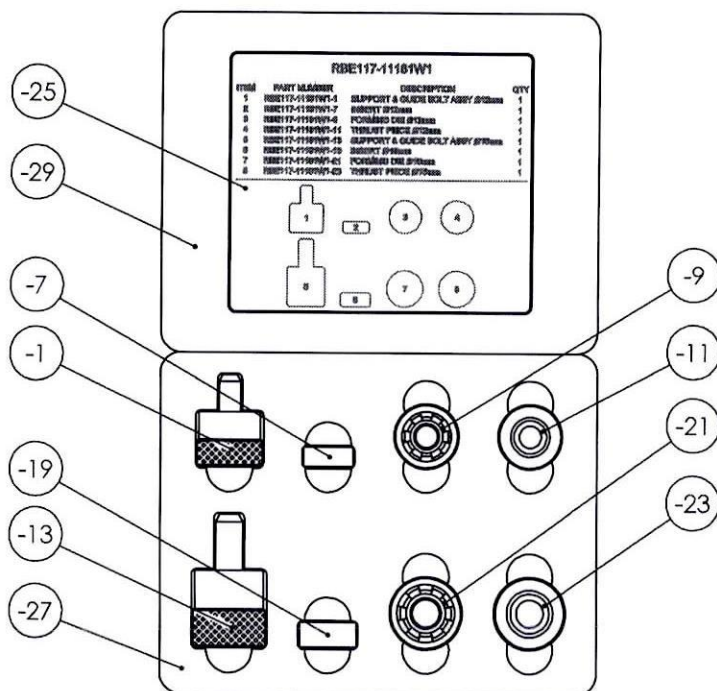
Part Specifications

Specifications could not be found.

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REVISIONS				
REV	ECR	DESCRIPTION	DATE	INITIAL
1		RELEASED FOR PRODUCTION.	7/18/2017	DPD
				JAG



NOTES:

1. REF. AIRBUS T/N: 117-11181W1.
2. USAGE: FOR THE REMOVAL & INSTALLATION OF THE SPHERICAL BEARINGS LN9367GE15N1 & LN9367GE12N1 SUPPORTED BY CLAW RINGS.
3. USED ON MODELS:
EC145, EC645, H145, H145M, BK117.

ASSY QTY	ASSY QTY	B/O	Part #	UNIT QTY	Description	Material	B/O INFORMATION OR SPECIFICATIONS	PG.
	X		-1	1	SUPPORT & GUIDE BOLT ASSY Ø12mm			2
	1		-3		SUPPORT Ø12mm	O-1		3
	1		-5		GUIDE BOLT Ø12mm	O-1		4
			-7	1	INSERT Ø12mm	O-1		5
			-9	1	FORMING DIE Ø12mm	O-1		6
			-11	1	THRUST PIECE Ø12mm	O-1		7
X			-13	1	SUPPORT & GUIDE BOLT ASSY Ø15mm			8
	1		-15		SUPPORT Ø15mm	O-1		9
	1		-17		GUIDE BOLT Ø15mm	O-1		10
			-19	1	INSERT Ø15mm	O-1		11
			-21	1	FORMING DIE Ø15mm	O-1		12
			-23	1	THRUST PIECE Ø15mm	O-1		13
			-25	1	CONTENTS PLACARD	PLASTIC		14
		B/O	-27	1	BOTTOM FOAM	ETHAFOAM 220, BLACK	2.90 X 7.27 X 9.47 (CASE SOLUTIONS)	15
		B/O	-29	1	TOP FOAM	ETHAFOAM 220, BLACK	1.16 X 7.27 X 9.46 (CASE SOLUTIONS)	16
		B/O	-31	1	CASE	PLASTIC	PELICAN #APP-1200-E	N/S
		B/O		1	DART PLACARD	ALUMINUM	RB41011	N/S
ASSY -13	ASSY -1							

DART AEROSPACE	
TITLE MAIN ROTOR DRIVE MOUNTING TOOL	
DWG NO. RBE117-11181W1	REV 1
MAT'L HEAT TREAT FINISH SPEC	UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES .XXX ± .005 FRACTIONS ± 1/8 .XX ± .01 ANGLES ± 5° .X ± .1 SURFACES = 125
DRAWN BY: DD 06/29/2017	1. BREAK ALL SHARP EDGES .015 x 45° OR .015R
CHECKED: RJC 06/30/2017	2. DIMENSIONAL LIMITS APPLY AFTER PLATING
OPPS APPR: AA 07/10/2017	3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009
QA APPR: JL 07/10/2017	USED ON MODEL
APPROVED: JAG 07/19/2017	SEE NOTE 3
SCALE 1:4	DATE 6/29/2017
SHEET 1 OF 16	



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER **PO039580**

Supplier: ARR002-VU
Arrow Tech Machine Works
29751 E. Enid Road,
Unit C
Eugene, OR 97402 USA
Phone: 541-780-6938
Fax: 458-215-4938

PO No: PO039580
PO Date: 4/11/18
Due Date: 6/2/18
Purchase Order
Revision:
Revision Date:
Ship-To Contact: Phone:

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Ship To:

Pymt Terms: Net 30
Freight Terms:
Special Comments:

Items											
Line Item	Part	Supplier Part No	Item No	Description	Status	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (USD)	Extended Price
1	RBEGM-745-064P			Removal/Installation-Motor Pump Cartridge (Forward Main Tank) WO 175829 AND WO 175826	Firmed	5/11/18	2 Ea	0 Ea	2 Ea	\$1,736.93/Ea	\$3,473.86
2	RBW109-3130-85-133P			Tool Kit, Tail Rotor Pitch Control Shaft Bearing Remove/Install WO 175827 AND WO175893	Firmed	5/25/18	2 Ea	0 Ea	2 Ea	\$1,766.68/Ea	\$3,533.36
3	RBEL133M-6503-101P			Mounting Tool	Firmed	5/18/18	2 Ea	0 Ea	2 Ea	\$1,753.73/Ea	\$3,507.46
4	RBD29828P			Elastomeric Bearing Removal Tool WO 175825	Firmed	6/4/18	2 Ea	0 Ea	2 Ea	\$551.91/Ea	\$1,103.82
5	RBW6305G00431-3GP			Hoisting Flange Main Gear Box WO 175830	Firmed	5/29/18	4 pcs	0 pcs	4 pcs	\$1,013.90/pcs	\$4,055.60
6	RBE117-11181W1P			Main Rotor Drive Mounting Tool WO 175881, WO 175882, WO 175883 WO 175885	Firmed	5/11/12	4 Ea	0 Ea	4 Ea	\$2,603.98/Ea	\$10,415.92
7	RBW6305G00132-3GP			AW139 Gimbal Bushing WO 175863, WO 175864, WO 175864	Firmed	5/29/18	3 pcs	0 pcs	3 pcs	\$1,080.39/pcs	\$3,241.17



ARROW TECH MACHINE WORKS

Certificate of Conformance

Your Purchase Order No:039580

Dated: 5/9/2018

Our Order / Job No: 06AWT

Order Qty: 4

Part Name: MAIN ROTOR DRIVE MOUNTING TOOL

Part Number: RBE117-11181W1

Lot Size: N/A

Ship Date: 5/9/2018

We certify that these parts shipped to you are of domestic or international manufacture and conform to all requirements of the Purchase Order. These parts have been manufactured and inspected in accordance with all required specifications, instructions and drawings. Any applicable specifications are listed below:

Drawing Number: RBE117-11181W1 Rev:1

Material Size and Type: -3,-5,-7,-9,-11,-15,-17,-19,-21,-23/0-1 STEEL

Material Specifications: 0-1 STEEL: ASTM A681

Heat Treatment: RC 50-55

Plating/Finish: BLACK OXIDE: QMSI-6.2.2 B.O. REV D

Mercury Contamination: The material used to process this order has not come in contact with mercury or mercury bearing instruments.

Date: 05/09/18

Signed: _____

PHGE Machine Works LLC dba Arrow Tech Machine Works
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